

Date: Monday, 21/07/2008 10:53:29 AM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT ARM
Job Number : 40683	
Estimate Number : 11488	
P.O. Number :	Part Number : D31651
This Issue : 21/07/2008 / S.O. No. :	Drawing Number : D3165 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/1 Type : MACHINED-PARTS	Drawing Revision : A
Previous Run : 36522	Material :
Written By :	Due Date : 10/08/2008 Qty: 6 Um: Each
Checked & Approved By : <u>JUL 08.7.21</u>	
Comment : Est. A 02.09.18 New issue KJ	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0500X05000	6061-T6 Bar .500 x 5.00
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Comment: Qty.: 1.4963 f(s)/Unit Total: 8.9775 f(s)

6061-T6 Bar .50" x 5.0"

Material: 6061-T6/T651 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) per (M6061T6B0500x5000)

Batch M108586 X2 M106182 X1

M109025 X233

08/08/03

⑥  
③

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut Blank: (17.00" x 5.00") +/- 0.030" x 0.500" thick

Grain along 17.000"

08/08/02

⑥  
③

3.0	HAAS1	HAAS CNC VERTICAL-MACHINING #1
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Comment: HAAS CNC VERTICAL-MACHINING #1

Machine as per Folio FA277 & Dwg D3165-1

Deburr & Tumble

08/09/24 / J1 08/09/25

P50

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

08/09/24

JL 08/09/25

5.0	QC8	SECOND CHECK
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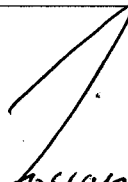


Comment: SECOND CHECK

08/09/25

33

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
08.09.25	6.0	Change Eng. Location, Now in Machine	Jul	08.09.24	N/A		S 08/09/25	

Part No: D3165-1 PAR #: NA Fault Category: Prod / Machine <sup>PNTS</sup> NCR: Yes No DQA: D Date: 08/10/03  
D205-633-015/025/026/024 QA: N/C Closed: D Date: 08/10/03

NCR: 40683		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/09/24	3.0	First part had wrong origine P.C. operator error. <del>forget to move</del> after		Scrap and Replace Batch# 109025 Qty 40	DJP 08/09/24	S 08/09/05		S 8/9/24
		checking hole forgot to move after checking the hole (i.e. mis-under stood Relio.		to read				S 8/9/24

NOTE: Date &amp; initial all entries

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User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ARM

Job Number: 40683

Part Number: D31651

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

HARS #1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Engrave batch number as per Dwg D3165

Ref 08/01/25

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-1 08/01/26

6X

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:15  
320 OF  
1:45

M-1 08/01/26

6X

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

8/9/26

50 6X

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

157 8/9/26

5X 54

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/02

Job Completion



MF 08-10-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

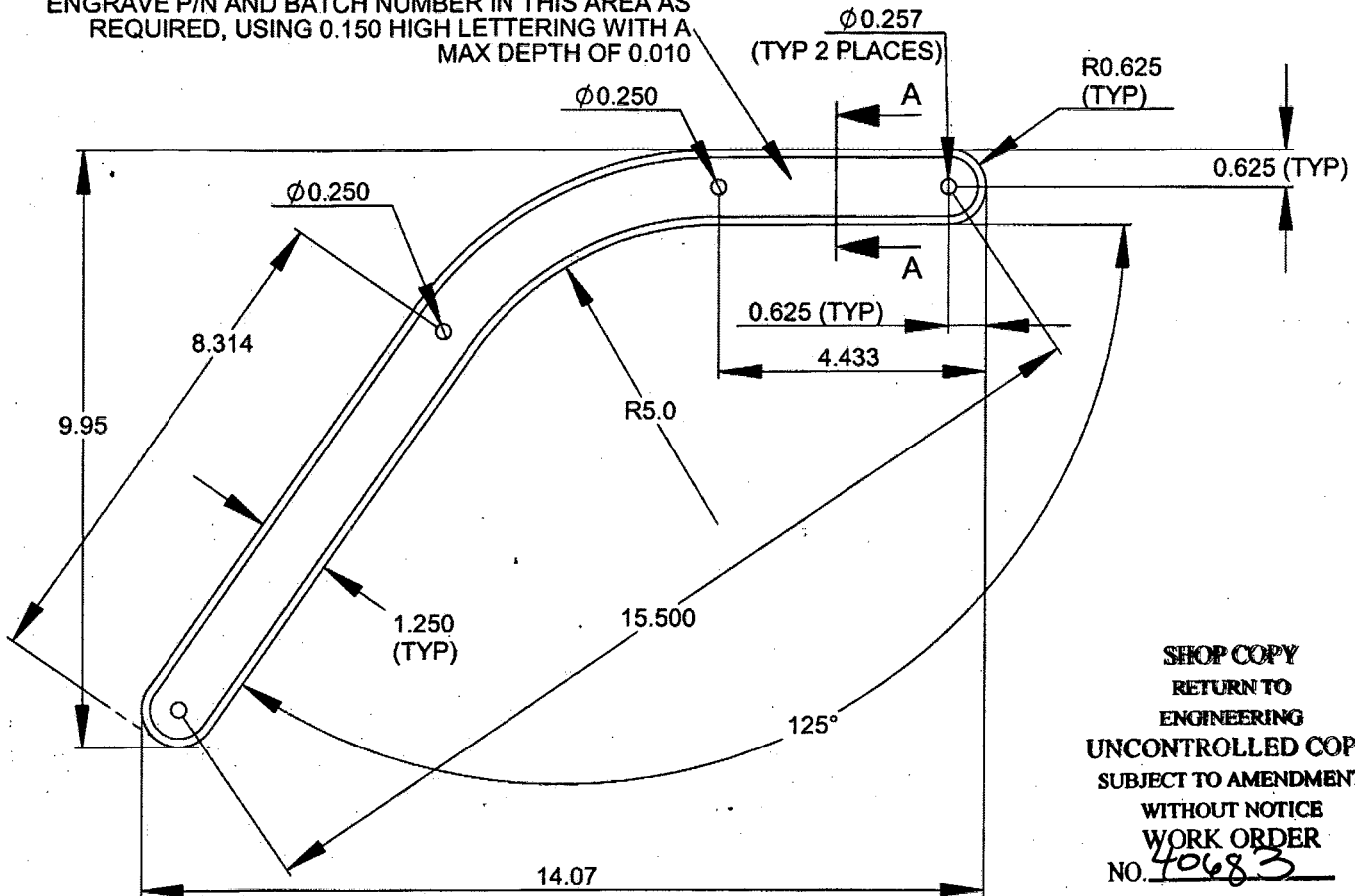
NOTE: Date & initial all entries





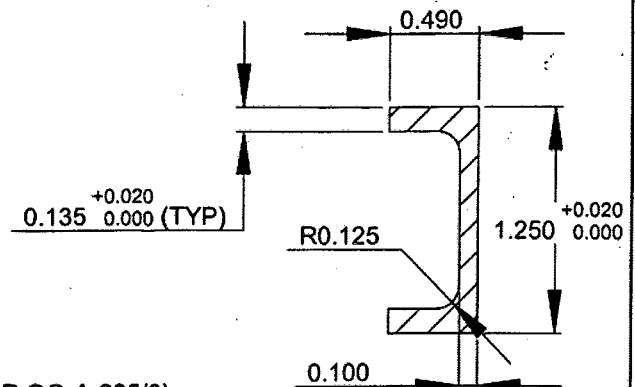
DESIGN <i>CP</i>		DRAWN BY <i>CP</i>		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>		APPROVED <i>[Signature]</i>		DRAWING NO. <b>D3165</b> <div style="text-align: right;">REV. A</div>	
DATE <b>02.07.09</b>		TITLE <b>SUPPORT ARM</b>		SHEET 1 OF 1 SCALE <div style="text-align: right;">1:3</div>	
A	02.07.09	NEW ISSUE			

ENGRAVE P/N AND BATCH NUMBER IN THIS AREA AS  
REQUIRED, USING 0.150 HIGH LETTERING WITH A  
MAX DEPTH OF 0.010



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 40683

RELEASED  
02.08.07



D3165-1 SUPPORT ARM

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)  
PER M6061T6B
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SECTION A-A  
SCALE (1 : 1)

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